

Work Order ID 84073

84073

Page 1

Wednesday, May 02, 2012 1:05:29 PM

Item ID: D3293-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 5/2/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3293	Rev A					8			

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

2024 .080

B12-5-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W 12.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

Small Fab

Memo

Small Fab

1- Deburr

0.00

140

0.00

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8

12:05:30

150

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

8

12:5:31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Item Name: Doubler
 Start Date: 5/2/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				8x	0		M-L 12/05/31
160									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 3:20	0.00							
	FINISH TIME: 3:50								
170	QC3- Inspect Part Finish	0.00				8	0		B 12-5-31.
170									
QC									
Quality Control	Memo								
180	Identify as per dwg & Stock Location: 87 211	0.00				8x			SP 12-6-1.
180									
Packaging									
Packaging	Memo								

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ME
12-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 1:05:34 PM

Page 1

Work Order ID: 84073

84073

Parent Item: D3293-1

D3293-1

Parent Item Name: Doubler

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A04.08.24New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.080

Purchased

No

100

sf

245.9700

1.8264

15.38021

LC

M2024T3S 080

**

B12-5-30

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT022

245.97

105411

6

109424

4

110347

0.5

112331

3

113796

5

114025

10.7

116604

5.8

117392

19.1

118180

46

119117

25.7

120989

120.17

120989

8

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DART



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		SHEET 1 OF 1	
04.06.28		DOUBLER		SCALE	
A		04.06.28		NEW ISSUE	
				REV. A	
				HAWKESBURY, ONTARIO, CANADA	

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

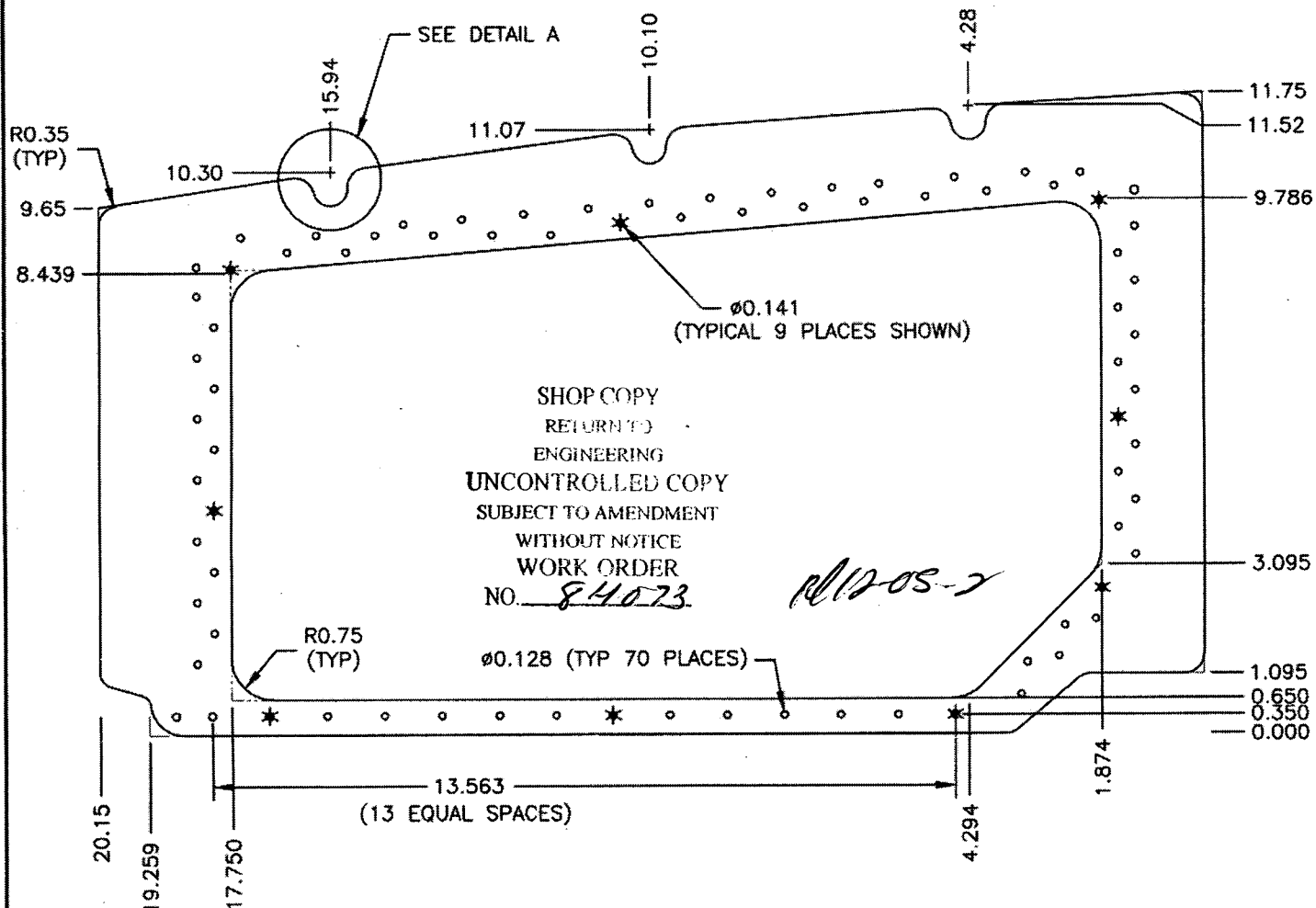
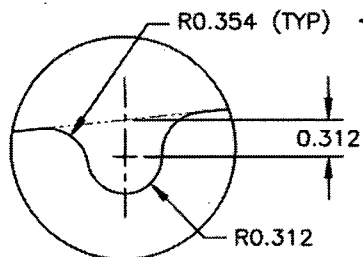
POWDER COAT BLACK SANOX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.28

DETAIL A
SCALE 2:3



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